









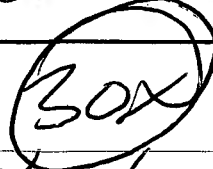




Date: Tuesday, 19/08/2008 4:04:06 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR SLUG
Job Number : 41433	
Estimate Number : 10162	
P.O. Number :	Part Number : D2587
This Issue : 19/08/2008 S.O. No. :	Drawing Number : D2587 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 38678	Material :
Written By :	Due Date : 29/08/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 08.8.19</u>	
Comment : Est D 04.05.31 Step 2 changed KJ/JLM Est E 06.07.31 Waterjet EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
1.0	M6061T6S040
	6061-T6 .040 Sheet
	 <u>1</u> 
Comment: Qty.: 0.0168 sf(s)/Unit Total: 0.3360 sf(s) 6061T6 alum. sheet 0.040" thick Batch: <u>106747</u> <u>HB 8-9-8</u>	
2.0	WATER JET
	FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D2587 Dwg Rev: <u>A1</u> <u>HB 8-9-8</u> Prog Rev: <u>A1</u>  2-Deburr if necessary <u>HB 8-9-16</u>	
3.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	 <u>HB 8-9-8</u> 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8
	SECOND CHECK
	 
Comment: SECOND CHECK <u>S. 08/08/17</u> <u>(+30)</u> counter 	
5.0	HAND FINISHING1
	HAND FINISHING RESOURCE #1
	 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>M. J.</u> <u>08/09/17</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR SLUG

Job Number: 41433

Part Number: D2587

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

08-09-17

X36

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 37

JS 08/09/17 (31)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18 JS

Job Completion



u 08/09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

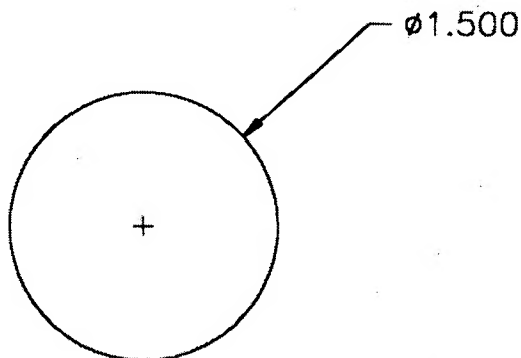
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED	APPROVED	D2587	SHEET 1 OF 1
M. M.	M. M.	TITLE	SCALE
DATE		DOOR SLUG	1:1
96:07:11			
AI [Signature] 03.09.16		ADD 6061-T6 OPTION	

RELEASED
9607/23 B.U



OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) AI

MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 4433